

Work Order ID 70817-54T

Wednesday, June 15, 2011 2:27:00 PM

Page 1

Item ID: D3537-3

Accept

Revision ID:

Item Name: Wearpad

Start Date: 6/15/2011 Start Qty: 12.00

Required Date: 6/22/2011 Req'd Qty: 12.00

Reference:

Approvals: Process Plan:

Date: 6/15/11 Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100



Waterjet

FLOW WATER JET

0.00

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 11 Dwg Rev: C 12-
Debur if necessary

10/11-6-22

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

10/11-6-22

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

8/6/22

7/12

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Item ID: D3537-3

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Setup Start



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Stop



Start Date: 6/15/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

0.00

Memo

0.00

Deburr if necessary Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3 Form Joggle as per Dwg D3537 on brake using Jig DT8158

SB 11/6/29

(12)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Ensure joggle as per dwg D3429

SB 11/6/29

(12)

150



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

Qty Description Batch 1A/R 2059B Hardcoat
M118196 Weld hardcoat as per Dwg D3437

EL 11-8-4

(11)

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Required Date: 6/22/2011 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8/10/07/04

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/07/04



180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

2:10
3200F 2:40

11x 4 M-L 11/07/05

M 115128

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Setup Start



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Item Name: Wearpad

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Start Date: 6/15/2011 Start Qty: 12.00



Required Date: 6/22/2011 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

u φ M u107/05

200

Identify as per dwg & Stock Location:

FP-17

0.00



Packaging

Memo

0.00

Packaging

11x φ M 11/07/05

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/05

MF

11-07-06

Picklist Print

Wednesday, June 15, 2011 2:27:06 PM

Page 1

Work Order ID: 70817

Parent Item: D3537-3

Parent Item Name: Wearpad





Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	69.7000	0.149	1.882105			
304/316 Sheet .063													

1811-12-22

Location

Loc Qty

Loc Code

MAT020

69.7

117275

2.3

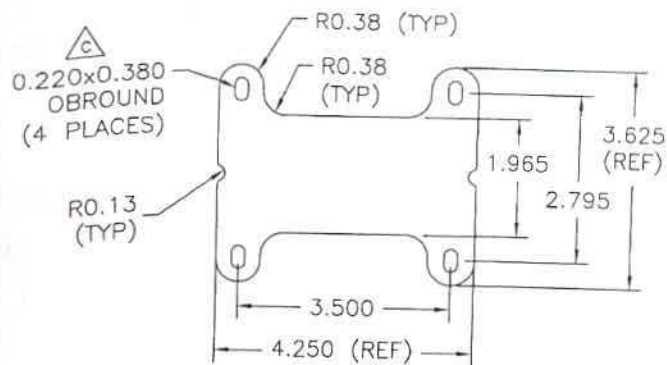
117653

67.4

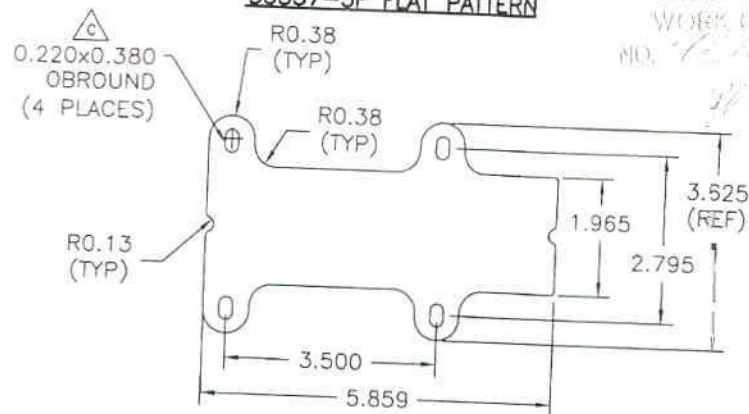
117653

(1.2)

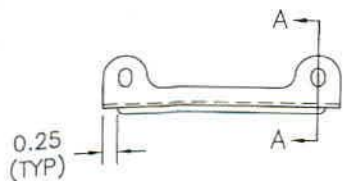
D3537-1F FLAT PATTERN



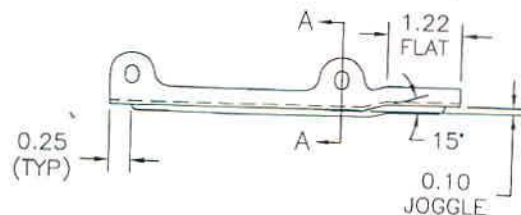
D3537-3F FLAT PATTERN



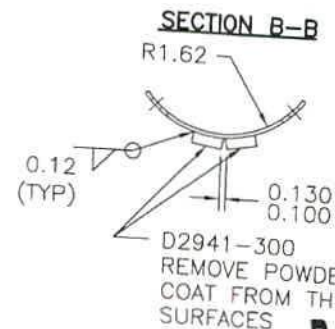
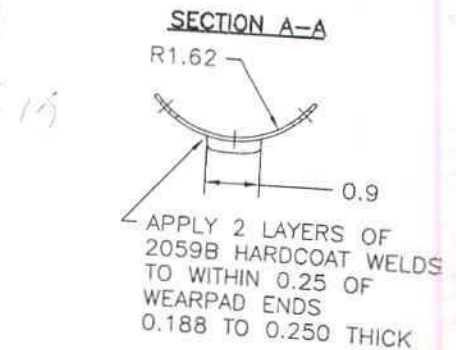
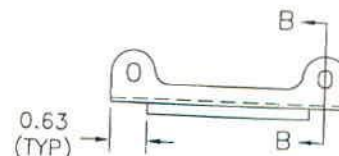
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



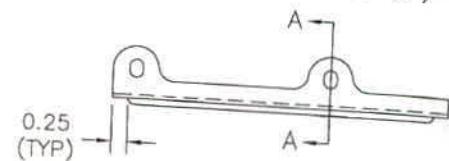
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DESIGN	07.04.13	WIDEN TAB TO 0.300, WELD PATTERN
CHECKED	07.03.20	ADD AMS 5513 AND AMS 5524
DATE	06.11.06	NEW ISSUE
DRAWN BY	PH	DART AEROSPACE USA, INC.
APPROVED	PH	PORT HADLOCK, MA
DRAWING NO.	D3537	REV. C
TITLE	WEARPAD	SHEET 1 OF 1
SCALE		1:2

RELEASED
07.05.08
per ECU
962